	r ID-92694 2:34:50 PM		*92	69	4*						Page 1
Revision ID:	D2360 Litter Tie Down Assembly		Accept	*	N900	040	100)* s	Setup Sta	1.7	S1* S2*
	11/07/12 Start Qty: 4.00	*4* *4*			Cust Item I Customer:	D:				IN	
Approvals:	Process Plan:MLJQC:	Date: \\7-\\-08	Tooling: SPC (Y/N):		· ······	nte:		I	Run Sta	1/1	R1* R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hour	s	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2341 D2360	Rev F Rev D										
*100 *100* Bandsaw Jeaspa Bandsaw	BAND SAW Memo	12.65" Long	0.00	PO	12/11	/28		4	Ø		
110 *110* HAAS 1	HAAS CNC VERTICA	L MACHINING #1	0.00								0AS - 25

Machine as per Folio D2341 and Dwg D2341 2-Deburr

HAAS CNC vertical machine #1

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Closed:	Date:	

											QA Closea:	Date:	
Work Orde	er: _					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap		ľ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Γherm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	۷o					Work Order Update	1		Large Fab	Composite		Supplier	1
											-		
Root					Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш	İ				:							
Operator									ł				
Material	Ш												
Setup													
Other													
Process	Ш												
Supplier													
Training	Ш							ļ					
Unapproved													
<u> </u>						FA	AULT (CATE	GORY				
Landi	ng Ge	ear				General					_	·	_
	В	ending				Bend	∐ Gı	rain			Ovalized		Pressure/Forced
		entre No	t Concer	ntric to (o/s	BOM/Route	Ha	ardwai	re		Over/Under	tolerance	Temperature/Cure
		racks				Broken/Damaged	lins	specti-	on Incomplete		Part Incorred	ct	Weld
	c	rushed/C	Crimped.			Burrs	ln:	structi	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		uffs				Contamination	Πм	lainte	nance		Part Moved		_
	Шн	leat Treat	t			Countersink	М	lislabel	led		Positioned V	Vrong	
	∐ Ir	nspection	Strip in	Tube		Cut Too Short	□м	lisread	ı		Power Loss/	Surge	Other
ĺ	R	ipples in	Bend			Drill Holes	Of	ffset			-	<u> </u>	
	Т	orque W	aves in E	xtrusio	ո [Drawing	Пог	ut of C	Calibration				
ļ	Т	urning Se	equence			Finish	O	ut of S	Sequence				
	V	Vave/Twi	ist in Tub	e		Folio	Ποι	utside	Dimensions				•••

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Work Orde November-07-12				*926	394*							Page 2
tem ID: Revision ID:	D2360			Accept	*N9000	040	100)*	Setup	Start	ı Vı .	S1*
	Litter Tie Dow	n Assembly								Stop	*N:	S2*
Start Date:	11/07/12	Start Qty: 4.00	*4*		Cust Item II):						
Required Date: Reference:	11/23/12	Req'd Qty: 4.00	*4*		Customer:							
Approvals:	Process Pla	n:	Date:	Tooling:	Da	te:			Run	Start	1/11	R1*
••					Da	te:				Stop	*NI	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00								DAG
120 QC Quality Control		Memo		0.00					* w		MAR	<u> 25</u> , 6
130		QC8- Inspect parts - seco	and check	0.00	-L12/11/29)						, DAS
130 QC Quality Control		Memo		0.00				Y		S		14
140 * 140 *		Chemical Conversion Co	oat per QSI005 4.1	0.00				4		a <i>l</i> s	ואירנו	420
HandFinish		Memo		0.00				7_		yes	10490	00

Hand Finishing

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		
			QA Closed:	Date:

									QA Closed.	Date.	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N	lo				Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update	1110	Large Fab	Composite	Nec/3tor	Supplier	differ
Root			·	Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling					3						
Operator			ļ		i						
Material											
Setup											
Other											
Process										_	
Supplier											
Training			ł								
Unapproved											
					F.	AULT CA	EGCRY				
Landir	ng Gear				General						
	Bendin	g			Bend	Grain	1		Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Hard	vare		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorred	ct	Weld
	Crushe	d/Crimped			Burrs	Instru	ctions Incomplete	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved		_
	Heat T	eat		Γ	Countersink	Misla	beled		Positioned V	Vrong	
,	Inspect	ion Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
Ţ	Ripples	in Bend			Drill Holes	Offse	t	N	•	<u> </u>	
	Torque	Waves in I	Extrusio	n	Drawing	Out	f Calibration				
Ī	Turning	Sequence			Finish	Out	f Sequence				
Ì	Wave/	Γwist in Tul	oe		Folio	Outsi	de Dimensions				

Work Ord November-07-1				*926	394*					Page 3	
Item ID: Revision ID: Item Name:	D2360 Litter Tie Dow	n Assembly		Accept	*N900	0401	იი*	Set	up Start Stop	*NS1* *NS2*	
Start Date: Required Date Reference:	11/07/12 : 11/23/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:			·		
Approvals:		n:	Date:			nte:		Rui	n Start Stop	*NR1* *NR2*	•
Sequence ID/ Work Center I 150 *150* Powdercoat Powder Coating 160 *160* QC Quality Control	./	Operation Description White Gloss(Ref:4.3.5.1) Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish Memo	IE: 8 // PERATURE:	Set Up/ Run Hours 0.00 0.00 0.00 0.00	Tool ID		Code Q	ty X-/2	Qty	Reject Insp. Number Stamp 12/11/30	1 - 30
170 Small Fab Small Fab		Small Fab Memo Assemble as	per dwg D2360 と Ø、みんな	0.00 0.00 (5.01.15			4	/X		Jo 13 p	/z/

												DQA:	Date:	
NCR: Y	es	/ No					WORK ORDER NON-C	:O1	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	:
Work Orde	r.			-		T	DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N NCR N	o						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Desc	ript	ion of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty			Non-conformance		ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved													·	
1 1					·			AUL	T CATE	GCRY				
, Landin	E	ear Bending Centre No Cracks Crushed/C Cuffs Heat Treat nspection Ripples in Forque Warning Se	Crimped. t Strip in Bend aves in E	Tube xtrusior			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of (ion Incomplete ions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Outside Dimensions

Wave/Twist in Tube

Folio

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Work Orde				*926	394*		··. · · <u>·</u>					Page 4
Item ID: Revision ID: Item Name:	D2360	Down Assembly		Accept	*N900	040	100)* s	etup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	11/07/12		*4* *4*		Cust Item II Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		te:		R	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 180 *180* QC Quality Control 190 *100* Packaging Packaging	D	Operation Description QC5- Inspect part comp Memo Identify as per dwg & St		Set Up/ Run Hours 0.00 0.00 1/3 2	Tool ID	Tool#	Plan Code	Accept Qty L	Rej Qty		Reject Number	Insp. Stamp
*200 *200* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00				• •••••••••••••••••••••••••••••••••••••		13/	12/0	0220

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Doc/Data Doc/Data			Date:	DQA:										
Work Order: Part No.			Date:	QA Closed:		MANCE / UPI	NFORI	WORK ORDER NON-C					s / No	NCR: Ye
Part No. Part No. Skid-tube Crosstube Prod. Eng. Coor. Quality			PROCESS	PARTMENT	AGAINST DEI			DISPOSITION						Work Order
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data		Quality	d. Eng. Coor e/Packaging		Small Fab Finishing	Machining noforming	1	Scrap Use-as-is	_					Part No
Doc/Data Doc/Data				Sign &	tion	Act	Initial	ption of work order update	escrip	D			1	Root
	or	QC Inspect	Verification	Date	ription	Descr	nief Eng	or Non-conformance	0	Qty	Q	Step	Date	Cause
Operator Operator														Equip/Tooling
Material								,		İ]	Material
Setup Setup													1	Setup
Other														Other
Process	ļ									ļ			1	Process
Supplier													1	Supplier
Training														Training
Unapproved		<u> </u>											<u> </u>	Unapproved
FAULT CATEGORY						<u>GORY</u>	LT CATE							
Landing Gear General	.	10 /5		O 11 1			٠	- ,					7	Landing
Bending Bend Grain Ovalized Pressure/Forced	L	•	<u> </u>		<u> </u>		-{	-	<u> </u>	-:- +- 0/0			⊣ ~	-
	ure	Temperature/Ci	<u> </u>				-1	-		10 to U/S	entric	ot Conce	4	-
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pu	المطالب				linelees.		-1	-	-			منسم م	-	-
Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pu Cuffs Contamination Maintenance Part Moved	neu	Wrong Stock Pu	22IIIR		<u> </u>		4	- ' '	-		u.	umpeo.	4	-
Heat Treat Contamination Invalide Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Part Moved Positioned Wrong Part Moved Part Move	İ		Vrong		 		-1	-	-			+	-1	-
Inspection Strip in Tube Cut Too Short Misraed Positioned Wrong Other		lother					┥		-	ıbo	n Tuk		-	-
Ripples in Bend Drill Holes Offset		Other	Juige	rower Loss/			-1	-		ane.	11 144	-	⊣	-
Torque Waves in Extrusion Drawing Out of Calibration						Calibration	-1	4		rusion	Fytri		⊣ ``	H

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Loc Oty

20

19

Loc Code

Manufactured

Location

86351 89161

ST009

Lock Handle

												DQA:	Dat	te: _	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UP	DATE					
		<u>-</u>									QA (Closed:	Dat	te:	
Work Orde	٥r.					DISPOSITION				AGAINST DE	PART	MENT/	PROCESS		
i i i i i i i i i i i i i i i i i i i						Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	۷o.					Scrap	1		Machining	Small Fab		Proc	d. Eng. Coor.		Quality
	•					Use-as-is	1	l	noforming	Finishing	R		e/Packaging		Other
NCR f	No.					Work Order Update	1		Large Fab	Composite			Supplier		
				` .			_				•				
Root					Descri	ption of work order update		Initial	Ac	tion	Sig	gn &		Ţ	
Cause	\Box	Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Desc	ription	C	ate	Verification	n	QC Inspector
Doc/Data	Ш										•				
Equip/Tooling											ļ			- 1	
Operator		I													
Material															
Setup															
Other															
Process															
Supplier															
Training													•		
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						F.	AUI	LT CATE	GORY	·					
Landi	ng G	Gear				General		_			_				
		Bending				Bend		Grain			Oval	ized			Pressure/Forced
1		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over	r/Under	tolerance		Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped,

Inspection Strip in Tube

Torque Waves in Extrusion

November-07-12 2:34:49 PM

Work Order ID:	92694							
Parent Item:	D2360					Start I	Date: 11/07/12	Required Date: 11/23/12
Parent Item Name:	Litter Tie Down Assembly					Start	Qty: 4.00	Required Qty: 4.00
D2367 Handle Knob	Manufactured	No		170	Each	10.0000	1	4 / 3/02/
			Location	Loc Oty		Loc Code		
			ST009 89083	10 10			3-	38,3541
D2372 Quick Release	Manufactured	No	0,000	170	Each	3.0000	2	8 8 spz
			Location	Loc Oty		Loc Code		
			GA	1				095/77
			86001 ST	1				- BV
			80274	2				000
D2373 Spring	Manufactured	No		170	Each	20.0000	1	4 S 13 for
			Location	Loc Oty		Loc Code		
			ST009	20				<u>.</u>
D2444 Pip Pin Assembly	Manufactured	No	86352	170	Each	7.0000	1	4 Si3h
			Location	Loc Oty		Loc Code		

GA

ST010

88498

91616

				•							DQA:	Date:	· · ·
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
Part I	Part No					Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root					Descri	ption of work order update	Ī	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	ν (or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	poling												
<u> </u>							AUL	T CATE	GORY				•
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ioris Incomplete/U nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	Ripples in Bend				Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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November-07-12 2:34:49 PM

Work Order ID: 92694 Required Date: 11/23/12 **Start Date:** 11/07/12 Parent Item: D2360 Parent Item Name: Required Qty: 4.00 Litter Tie Down Assembly Start Qty: 4.00 D6201 100 1.054 No 63.9386 4.4378948 Manufactured "T" Extrusion Location Loc Qty Loc Code MAT004 22.04 57767 1.34 71208 0.7 89645 20 MAT028 41.89863153 21.8986315 20 83987 170 MS20470AD3-4 No Each 8,431.0000 Purchased Rivet, Universal Head Location Loc Qty Loc Code ST319 8431 8332 111477 99 15541 MS21042L3 No 170 Each 2,592.0000 Purchased Nut Location Loc Oty Loc Code 316 619 122452 619 ST300 225 32 117885 55 119017 119075 138 ST314 1385 123265 1385 363 ST317 122141 363 170 69.0000 MS27039-1-13 Each No Purchased Screw Location Loc Qty Loc Code ST291 69 119736 69

									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	PDATE	QA Closed:	Date:	
Work Order	r·				DISPOSITION		,	AGAINST DE	PARTMENT	/PROCESS	
VVOIR OTGET	·				Rework		Skid-tube Crosstube			Water Jet	Engineering
Part No.					Scrap			Pro	d. Eng. Coor.	Quality	
					Use-as-is				• • • • • • • • • • • • • • • • • • • •	Other	
NCR No.				Work Order Update] [Large Fab Composite			Supplier		
Root				Descrip	tion of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				-					-		
quip/Tooling											
Operator											
Material		1									
Setup											
Other										Y	·
Process											
Supplier											
Fraining	aining										
Jnapproved											
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	FAULI CATEGURY							
Landing	g Gear	General		_		_		_
	Bending	Bend		Grain		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld
	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved		_
	Heat Treat	Countersink		Mislabeled		Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset				
	Torque Waves in Extrusion	Drawing		Out of Cal'bration			·	
	Turning Sequence	Finish		Out of Secluence			·	
	Wave/Twist in Tube	Folio		Outside Dimensions				

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November-07-12 2:34:50 PM

Work Order ID:	92694						
Parent Item:	D2360				Start	Date: 11/07/12	Required Date: 11/23/12
Parent Item Name:	Litter Tie Down Assembly				Star	rt Qty: 4.00	Required Qty: 4.00
MS27039-1-15 Screw	Purchase	d ^{No}		170 Eac	th 113.0000	2	8 \$3/02/5
			Location	Loc Qty	Loc Code		
			308	. 10			
			122459	10			<u></u>
			ST291	3			- M123352
	-		118574	2			_
			119736	1			_ (.82)
			ST305	100			
			123352	100			- //
NAS679A3W	Purchase	d No		170 Ea	ch 184.0000	1	4 Dr3/01
Nut	≠ ′	•	Location	Loc Qty	Loc Code		
•			GA	5			
			1463	5			<u> </u>
			2409	179		Ш	_

									DQA:	Date:	
NCR: Ye	NCR: Yes / No		WORK ORDER NON-C	CONFORM	MANCE / UP 		QA Closed:	Date:			
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
	Part No.				Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Water Jet Prod. Eng. Coor Rec/Store/Packaging		Engineering Quality Other	
NCR No.			Work Order Update	i mem	Large Fab	Composite	Rec/Sto	Supplier	Other		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											,
quip/Tooling											
Operator					•		,				
Material				٠							
Setup											,
Other											
Process					•						
Supplier											
Training											
Inapproved	7					1					

Landing Gear General Bending Bend Grain Pressure/Forced Ovalized BOM/Route Centre Not Concentric to O/S Hardware ' Temperature/Cure Over/Under tolerance Cracks Broken/Damaged Inspection Incomplete Weld Part Incorrect Crushed/Crimped. Burrs Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Mislabeled Heat Treat Countersink Positioned Wrong Inspection Strip in Tube Cut Too Short Other Power Loss/Surge Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Out of Calibration Drawing Turning Sequence Finish Out of Secuence Wave/Twist in Tube Folio Outside Dimensions

FAULT CATEGORY

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DART AEROSPACE LTD	Work Order:	92694
Description: Litter Tie Down Bracket (Locking)	Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.749			vern	12-10
2.75	+/-0.030	2.757			1	
Ø0.242	+0.005/-0.001	242			~	
Ø0.191	+0.005/-0.001	-191	1		^	
R0.25	+/-0.030	1.25	//			
R0.40	+/-0.030	-40	7			
12.50	+/-0.030	12.507			J+G	
11.750	+/-0.010	11.752	/		win	CNC-08
11.00	+/-0.030	11-002			~	
7.00	+/-0.030	7.002			~	
6.250	+/-0.010	Q-251	7		·n.	
5.50	+/-0.030	5,501			<i>kin</i>	DL-10
1.50	+/-0.030	1,503				
0.750	+/-0.010	753				
0.400	+/-0.010	-403				
1.584	+/-0.010	1.585				
2.610	+/-0.010	2.611				
0.250	+/-0.010	-250				
0.844	+/-0.010	-844				
Ø0.250	+/-0.010	1250				
0.750	+/-0.010	753	/			
3.313	+/-0.010	13.312				
4.250	+/-0.010	4250				
1.250	+/-0.010	1.249				

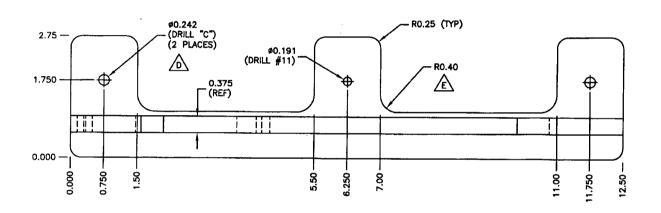
Measured by:	Audited by:	and	Prototype Approval:	N/A
Date: 12-1-29	Date:	12/11/29	Date:	N/A

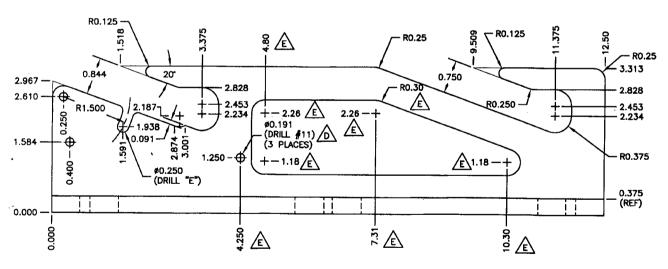
Rev	Date	Change	Revised by	Approved
Α	06.05.24	New Issue P/O D2360	KJ/JLM	
В	07.07.17	Dwg Rev. updated	KJ/JLM , A	
С	10.02.02	Dimensions updated	KJ KJ	W



DESIG	1	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. F
~	-A3	124	D2341 SHEET 1 OF 1
DATE			TITLE SCALE
07.0	06.07		LITTER TIE DOWN BRACKET (LOCKING) 1:2
Α		95.01.13	NEW ISSUE
В		95.02.14	MODIFIED LOCK
D		95.02.20	CHANGES TO DIAMETERS
Ε		97.10.01	CHANGES FOR MACHINING
F		07.06.07	REVISED NOTES: FINISH WAS ANODIZE

RELEASED





1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION

(6061-T6/T651 PER QQ-A-200/8)

- (6061-T6/T651 PER QQ-A-200/8)

 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010

 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

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WORK OKAN

UNCONTROL : SUBJECT TO A W.



	DESIG	[™] BW	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECH	ÆD	APPROVED	DRAWING NO. REV. D
l		-E	ar	D2360 SHEET 1 OF 2
	DATE			TITLE SCALE
	07.0	06.06	 	LITTER TIE DOWN ASSEMBLY (LOCKING) NTS
	Α		95.02.10	NEW ISSUE
	В		95.02.20	RE-DESIGN
	С		97.08.27	ADD MS20470AD3-4 RIVET
	D		07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)



PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
Х	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT





DESIGN

BW

CB

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

D2360

SHEET 2 OF 2

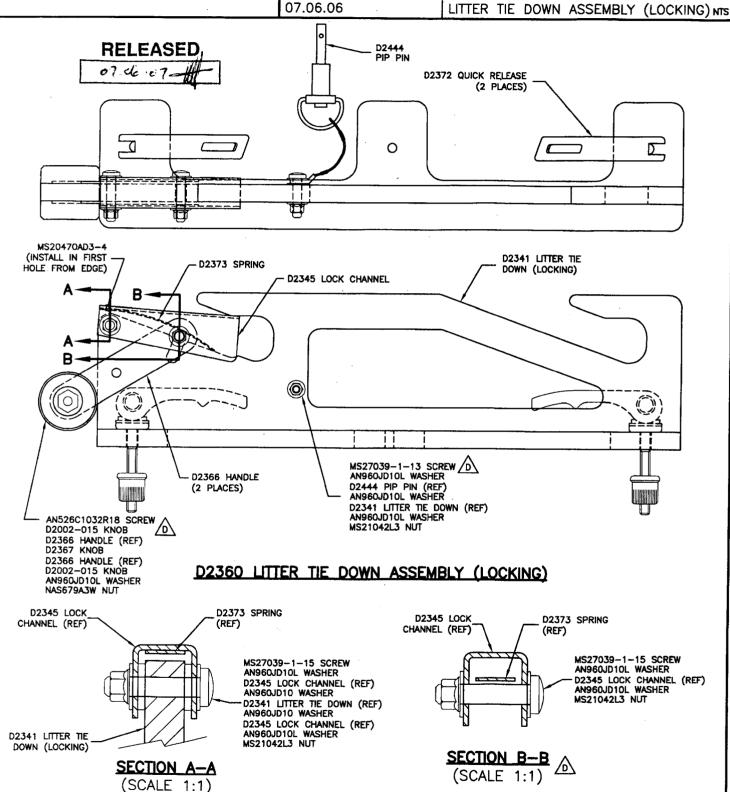
TITLE

TITLE

SCALE

O7.06.06

LITTER TIE DOWN ASSEMBLY (LOCKING) NTS



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